

Work Order ID 56245

Wednesday, February 17, 2010 11:03:07 AM

Page 1

Item ID: D2421

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, 900

Start Date: 2/18/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2421

Rev F2

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per file D2421_BLANK

B 10-2-17



130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

10/02/24

8 0

- 1-Inspect material for defects or damage prior to machining
- 2-Machine as per Folio FA124 and Dwg D2421
- Identify as D2421
- 3-Deburr

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56245

Wednesday, February 17, 2010 11:03:07 AM

Page 2

Item ID: D2421

Accept

Revision ID:

Item Name: Bearpaw, 900

Start Date: 2/18/2010 Start Qty: 8.00

Required Date: 3/4/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

150

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: APP

0.00

Packaging

Memo

0.00

Packaging



0.00 *amk 10/02/24*

8 0

0.00 *8.8 10/02/25*

8 0

10/03/08 (8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56245

Wednesday, February 17, 2010 11:03:07 AM

Page 3

Item ID: D2421

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw, 900

Start Date: 2/18/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 AJ
MF 10-35

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:03:06 AM

Page 1
T

Work Order ID: 56245



Parent Item: D2421

Parent Item Name: Bearpaw, 900

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments:

Start Qty: 8.00

Required Qty: 8.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | No | | | 120 | sf | 457.9905 | 32.0000 | | | |



UHMW 1" Black



18 10-2-17

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 426.2428 | |
| 112186 | 122.0164 | |
| 113166 | 28.6264 | |
| 113903 | 275.6 | |
| Main Warehouse | | |
| ST | 31.7477 | |
| 111354 | 31.7477 | |

8

113903

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|----------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 56245 |
| Description: Bearpaw | | Part Number: D2421 |
| Inspection Dwg: D2421 | Rev: F2 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A | 0.20 | +/-0.030 | .191 | ✓ | | | |
| B | 0.95 | +/-0.030 | .944 | ✓ | | | |
| C | 0.45 | +/-0.010 | .460 | ✓ | | | |
| D | 0.07 x 45° | +0.030/-0.010 | .065x45° | ✓ | | | |
| E | 0.69 | +/-0.030 | .685 | ✓ | | | |
| F | 0.38 | +/-0.010 | .390 | ✓ | | | |
| G | 0.44 - 0.47 | +/-0.000 | .450 | ✓ | | | |
| H | R0.25 | +/-0.030 | R.250 | ✓ | | | |
| I | 0.19 x 45° | +/-0.030 | .170x45° | ✓ | | | |
| J | 23.00 | +/-0.030 | 23.000 | ✓ | | | |
| K | Ø0.260 | +0.005/-0.000 | Ø.260 | ✓ | | | |
| L | Ø0.93 | +/-0.030 | Ø.930 | ✓ | | | |
| M | 0.30 | +/-0.030 | .320 | ✓ | | | |
| N | 4.50 | +/-0.030 | 4.500 | ✓ | | | |
| O | 9.50 | +/-0.030 | 9.500 | ✓ | | | |
| P | 1.00 | +/-0.030 | 1.000 | ✓ | | | |
| Q | 14.750 | +/-0.010 | 14.750 | ✓ | | | |
| R | 0.38 | +/-0.030 | .381 | ✓ | | | |
| S | 4.54 | +/-0.010 | 4.540 | ✓ | | | |
| T | 19.00 | +/-0.030 | 19.000 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |

| | | | |
|-------------------------------|------------------------------|----------------------------|-----|
| Measured by: <i>SM</i> | Audited by: <i>LB</i> | Prototype Approval: | N/A |
| Date: 10/02/24 | Date: 10/02/25 | Date: | N/A |

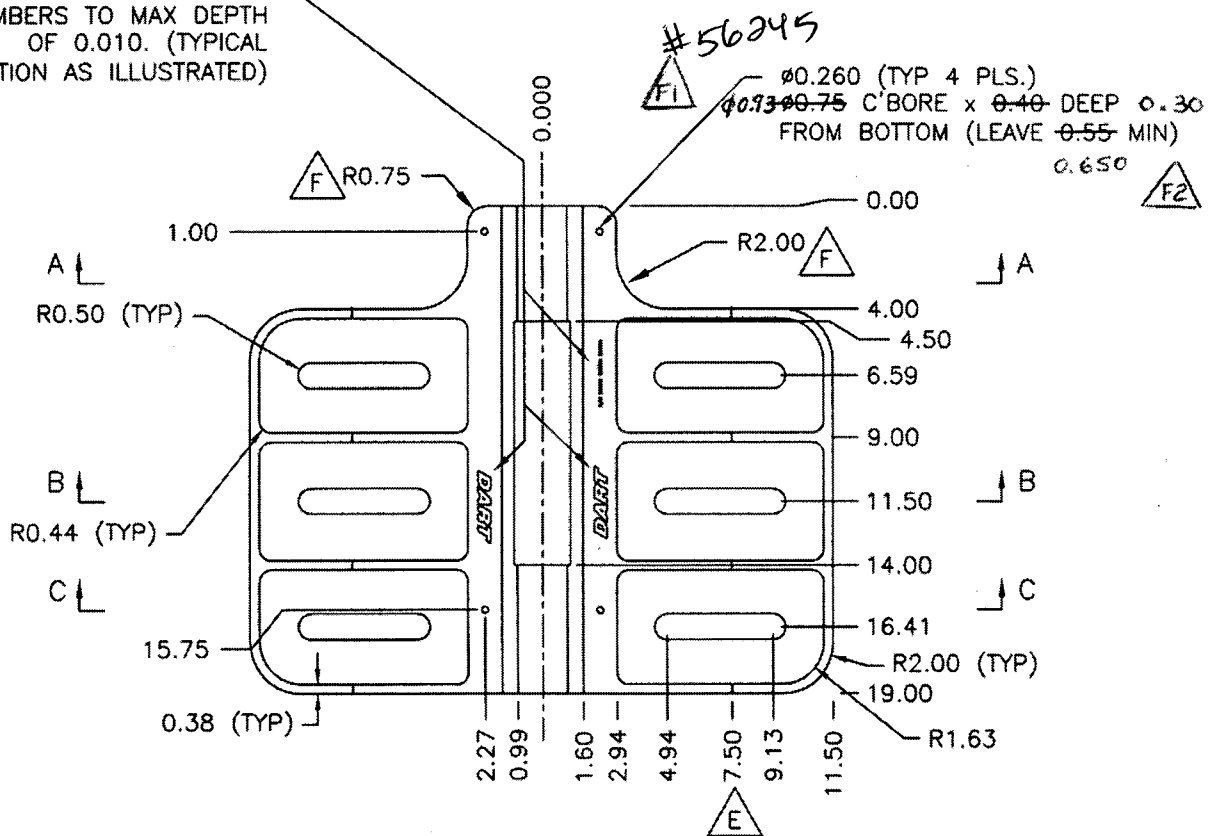
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------|------------|--------------------|
| A | 03.09.22 | New Issue | P/O K10010 | KJ/RF |
| B | 04.11.29 | Revised dimension M | KJ/JLM | <i>[Signature]</i> |

DART

| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RF</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2421 | REV. F SHEET 1 OF 2 |
| DATE 01.03.12 | | TITLE BEARPAW | SCALE 1:7 |
| A | 95.04.24 | NEW ISSUE | |
| B | 95.11.28 | CHANGED NUMBER OF HOLES | |
| C | 97.06.19 | ADDED MATERIAL SPECIFICATION | |
| D | 98.08.11 | DIM MODIFICATIONS | |
| E | 00.03.01 | R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155 | |
| F | 01.03.12 | MODIFY FWD END | |
| F1 | 03.01.13 | Ø0.93 WAS Ø0.75; R0.19 WAS R0.38; Ø0.19 WAS 0.25 | |
| F2 | 04.11.03 | 0.30 WAS 0.40 ; 0.650 WAS 0.55 | |

RELEASED
01.03.14 *[Signature]*

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

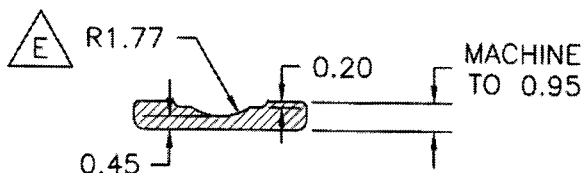
Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



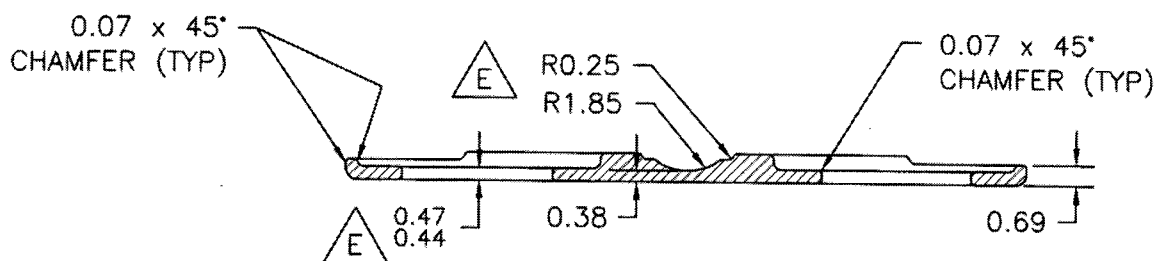
| | | | |
|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED RF | APPROVED # | DRAWING NO. D2421 | REV. F SHEET 2 OF 2 |
| DATE 01.03.12 | | TITLE BEARPAW | SCALE 1:6 |

RELEASED
01.03.14 #

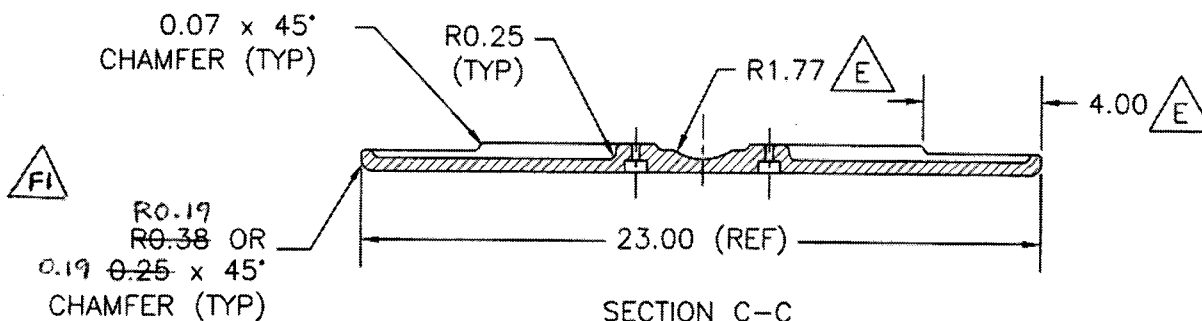


SECTION A-A

#56245.



SECTION B-B



SECTION C-C

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.